

Date: Thursday, 16/10/2008 10:44:23 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY (350)
Job Number : 42628C	
Estimate Number : 10189	
P.O. Number :	Part Number : D2221
This Issue : 16/10/2008 S.O. No. :	Drawing Number : D2221 REV G
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 42625C	Material :
Written By :	Due Date : 05/11/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.10.16</u>	
Comment : Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC	

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 D31661 Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty Part Number Description Batch

4 D3166-1 RIB B412716

SAD 08/10/05

2.0 D22323 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge bracket B39334

SY 08/11/12

3.0 D2325 Support Gusset (350 Basket)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Pick:

Qty Part Number Description Batch

4 D2325 Support Gusset B38741

SY 08/11/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:	Machine Or Operation:	Description :
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4.0	D23273	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D2327-3 Bushing B 39560

SY 08/11/11

5.0	D2581	Mounting Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D2581 Mounting Bracket B 40895

SY 08/11/11

6.0	D34421	Shim
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

✓ Qty Part Number Description Batch
2 D3442-1 Shim B 40392

SY 08/11/12

7.0	M304EX07516F	Expanded Metal Flat SS
-----	--------------	------------------------



Comment: Qty.: 41.6745 sf(s)/Unit Total : 41.6745 sf(s)

Pick:

Qty Part Number Description Batch
39.69 sf M304EX0.75-16F Expanded Metal M 108474 (4)
M 109383

SAD 08-11-13 ⑤

8.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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Comment: Qty.: 29.4000 f(s)/Unit Total : 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.065 wall 304/316 SS tubing
Batch: M 109 731

SAD

08/10/10

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235 ✓

2-Drill hole in D2221-3 as per Dwg D2221 ✓

3-Deburr ✓

4-Remove all markings on material before welding ✓

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required ✓

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

1- Plug holes in D2581 prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

***** 2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:15
01F
400
9:45

10:30
01F
400
11:00

M. 08/11/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Seq. #:

Machine Or Operation:

Description :

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/11/20 (EC)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/24 JF

Job Completion



mf 08-11-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

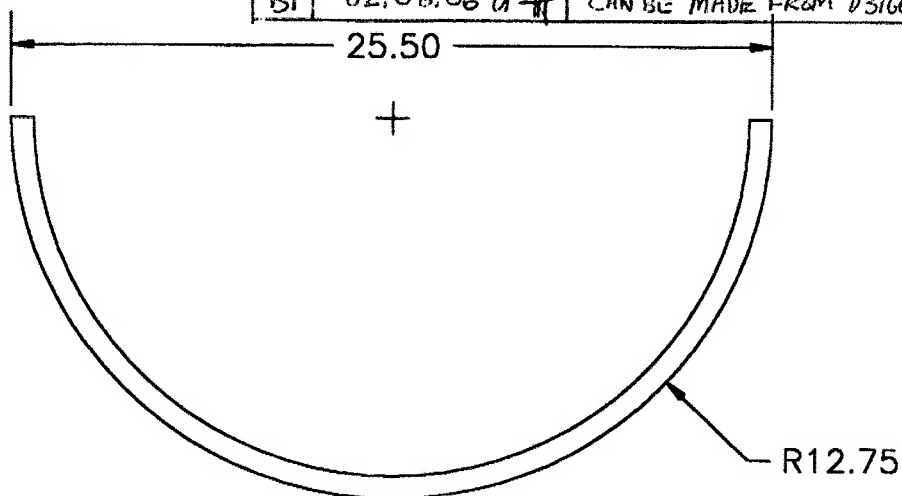
DART



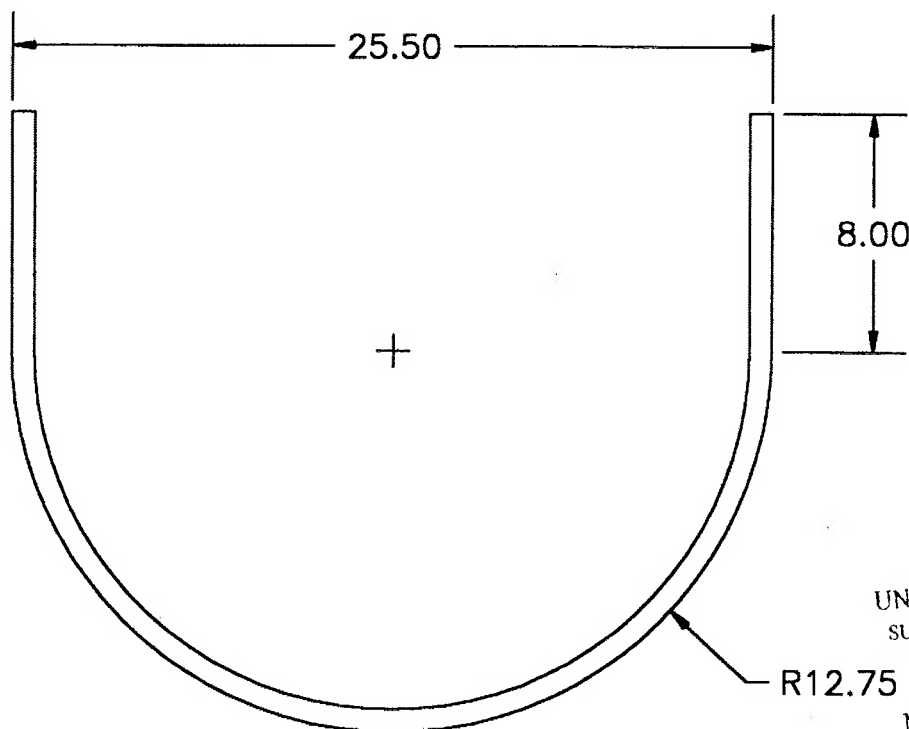
DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	

BI 02.08.06 *[Signature]* CAN BE MADE FROM D3166-1

RELEASED
R 960507



D2235-1



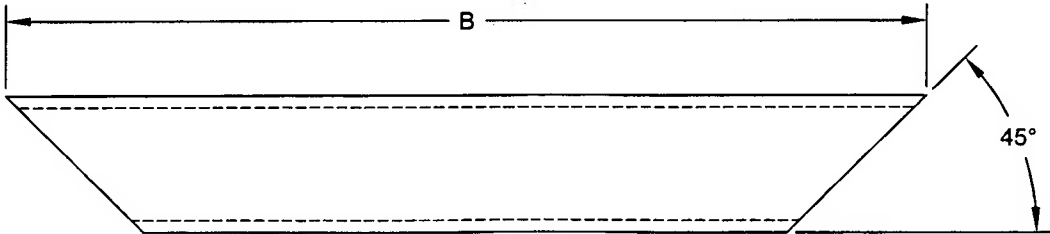
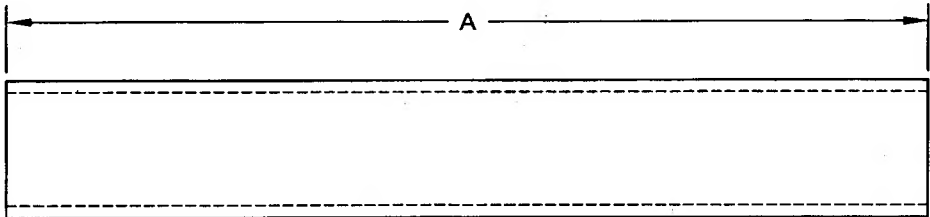
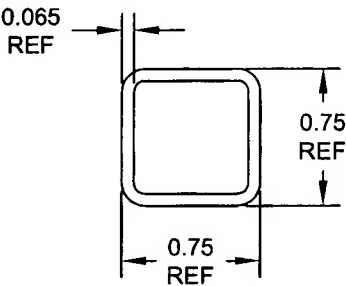
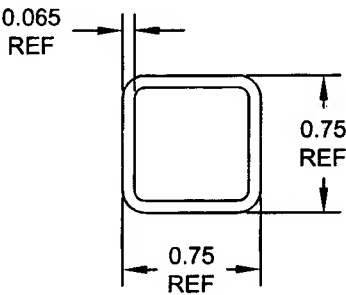
D2235-3

CAN BE MADE FROM D3166-1 *[BI]*
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *42628*

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	————	96.00	RIB
D2221-3	2	————	25.50	RIB
D2221-5	2	18.88	————	RIB
D2221-7	1	55.25	————	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D3442-1	2	N/A	N/A	SHIM



D2221-1/-3/-5/-7

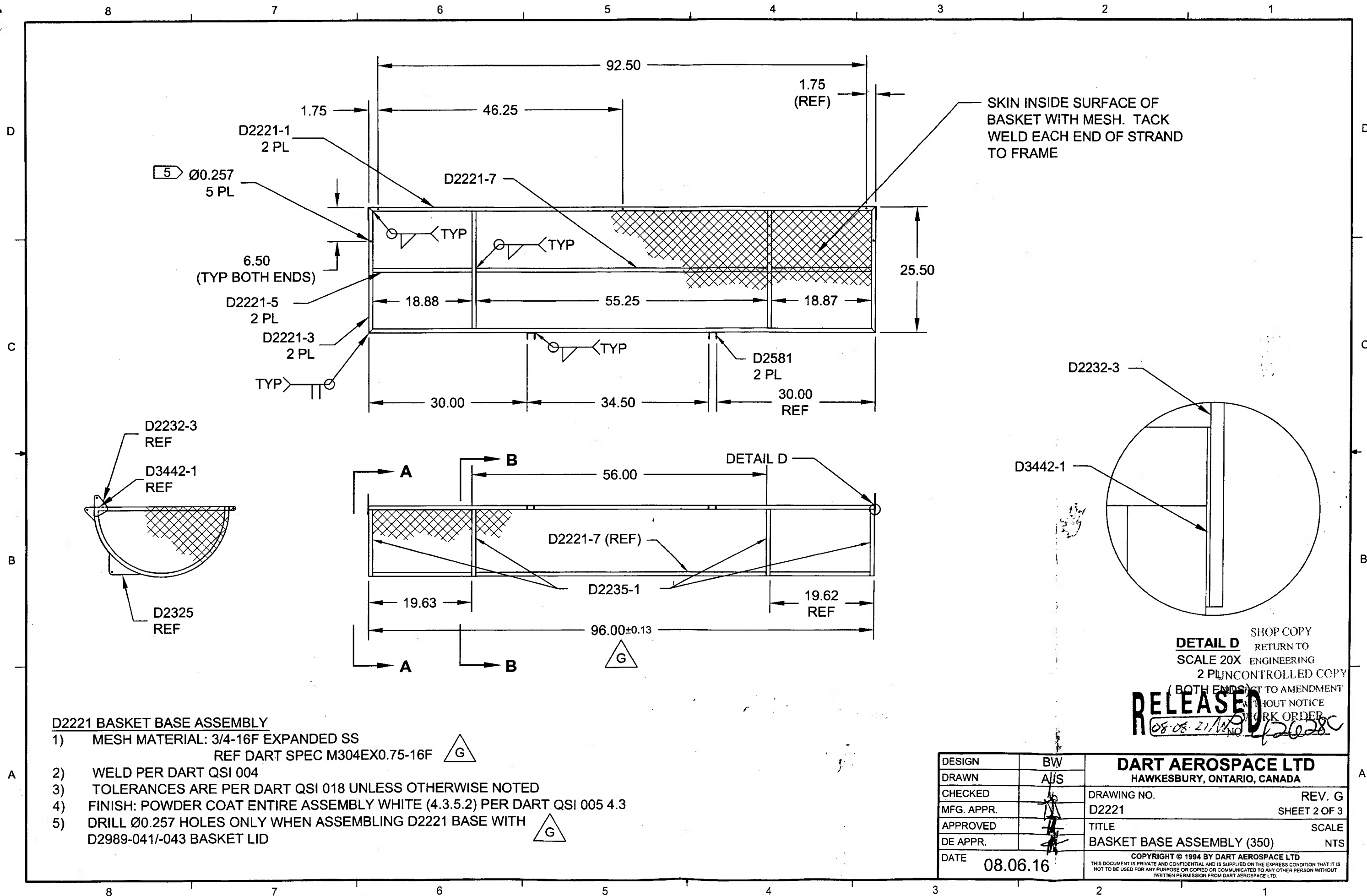
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

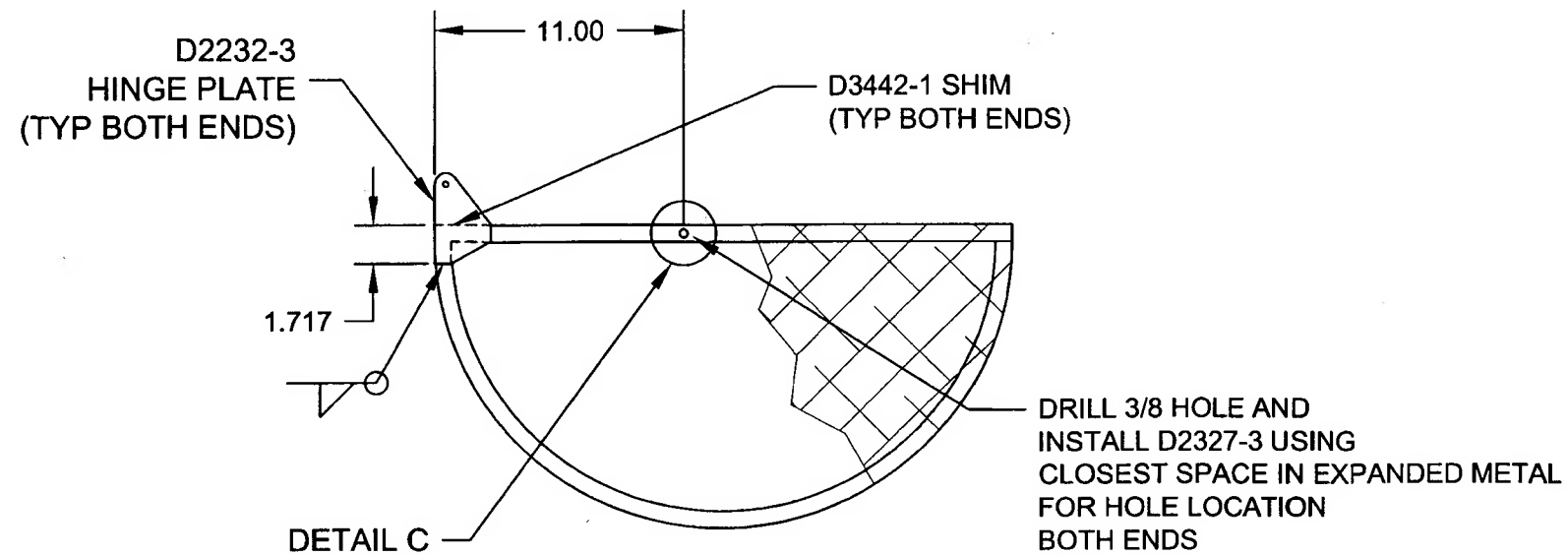


RELEASED

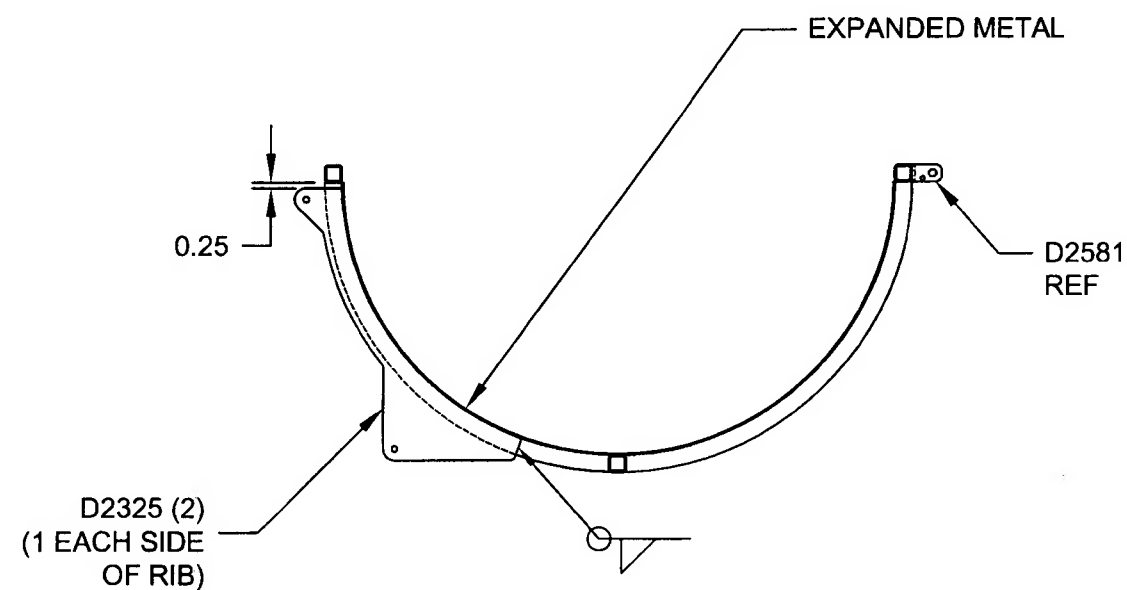
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WORK ORDER
NO. 42128

G	MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 2 ZN B,5 TOLERANCE FOR 96.00 DIM WAS +/- 0.01, 56.00 DIM WAS REF. SHT 2 ZN B4 19.62 DIM WAS "HARD" DIMENSION IS NOW REF.NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED. DRAWING TRANSFERRED TO "B" FORMAT.	AJS	08.06.16
F	ADD SHIM UNDER HINGES. ADD HOLES FOR SPLIT LID BASKETS	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPERATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2221	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.06.16	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

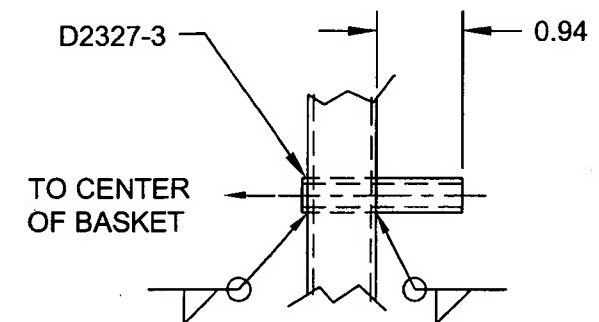




SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS



**DETAIL C
SCALE 4X**

RELEASED
08-08-2010

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WORK ORDER
NO. 42502

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2221	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.06.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

